

**METHODS OF STRETCHING FILMS AND SUCH FILMS**  
**ABSTRACT OF THE DISCLOSURE**

5 A method of biaxially stretching a polymeric film along an overbias stretch  
profile. The method comprises the steps of: ) imparting a sufficiently high  
temperature to the film to allow a significant amount of biaxial stretch; and b) biaxial  
tenter stretching the film to a final first direction stretch parameter and a final second  
direction stretch parameter, wherein at least 75% of the final first direction stretch  
parameter is attained before no more than 50% of the final second direction stretch  
10 parameter is attained, and wherein the final first direction stretch parameter is no  
greater than the final second direction stretch parameter.

An alternative method comprises a method of biaxially stretching a polymeric  
film along an overbias stretch profile. The method comprising the steps of:  
a) imparting a sufficiently high temperature to the film to allow a significant amount  
15 of biaxial stretch; and b) biaxial tenter stretching the film according to a stretch  
profile to a final first direction stretch parameter and a final second direction stretch  
parameter, wherein the final first direction stretch parameter is no greater than the  
final second direction stretch parameter. In such a method: i) a straight line between  
the point defining zero stretch parameter and the point defining the final first and  
20 second direction stretch parameters represents a proportional stretch profile and  
defines a proportional stretch area; and ii) the curve representing the stretch profile  
between the point defining zero stretch parameter and the point defining the final first  
and second direction stretch parameters defines an area at least 1.4 times the  
proportional stretch area.

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